

R0015300 Rotary Ring pneumatic test

Pneumatic function test for Rotary Ring

 Difficulty **Medium**

 Duration **1 hour(s)**


Contents

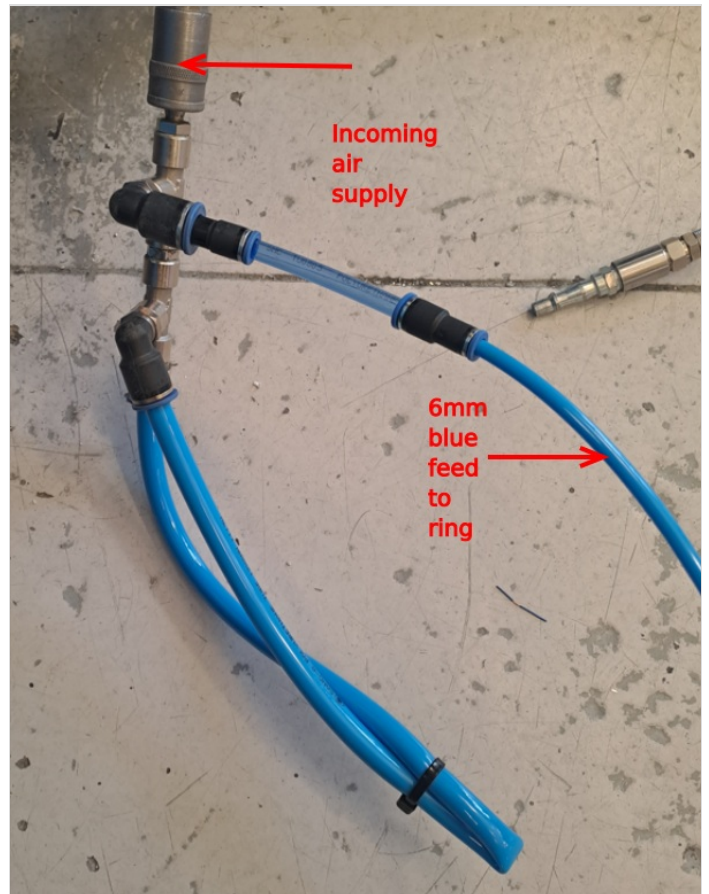
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Step 1 - Connect air feed

Compressed air feed needs connecting to main 6mm blue feed pipe to ring.

Use adapter to enable safe connection via PCL coupling and probe

 ...Spindles may move when air feed is connected. Ensure no parts or persons are in the areas of movement

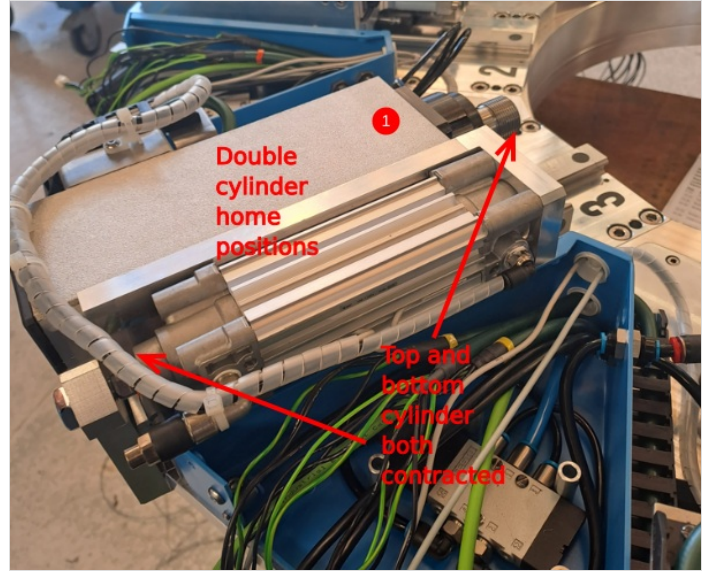
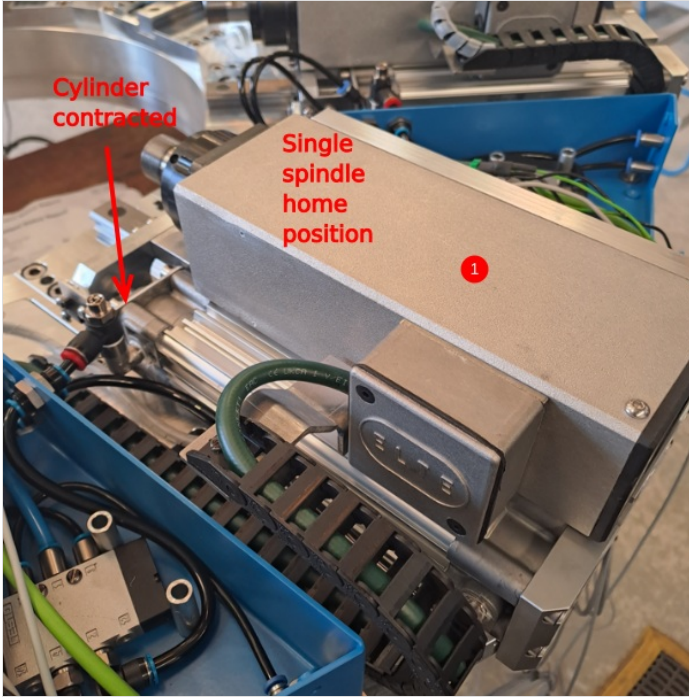


Step 2 - Check for air leaks

When air is connect to rotary ring, attention should be paid to any audible air leaks. If any are present, identify source and rectify

Step 3 - Home positions

1 When air is connected, all cylinders should be in a contracted state. This is their home position



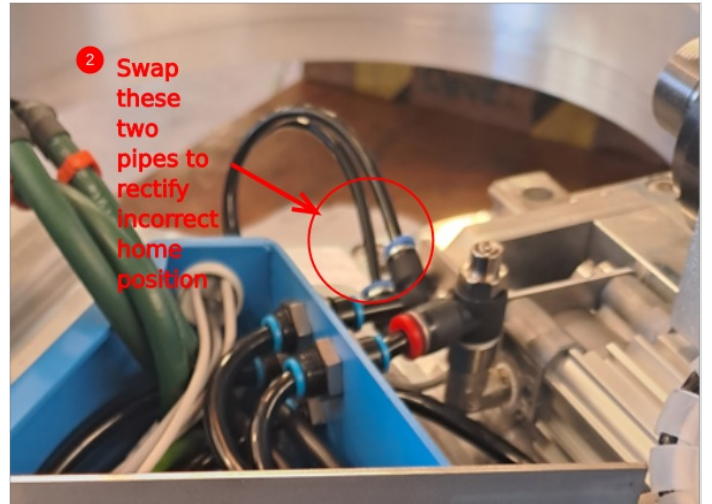
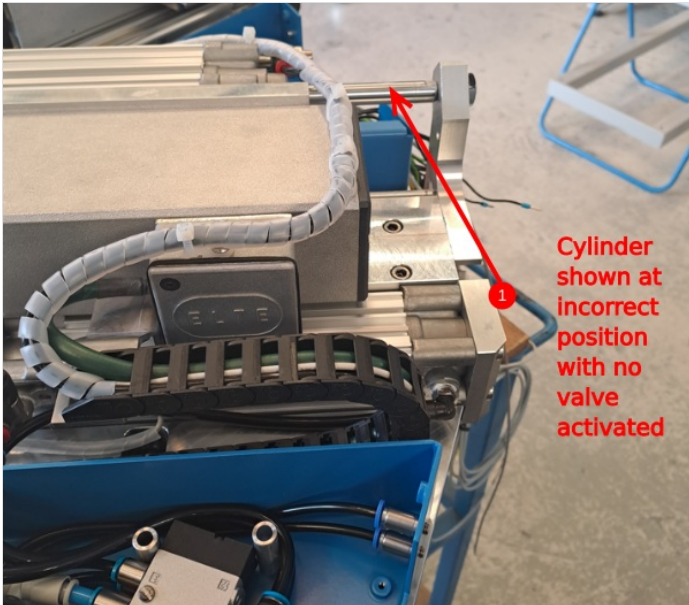
Step 4 - Home position correction

If correct practice has been followed, only the double slide cylinder will have the possibility of being at the incorrect home position. This is easily rectified

1 Image shows incorrect position when air has been connected to mains supply

2 To rectify, disconnect mains air feed and swap the two indicated pipes at the stem elbows

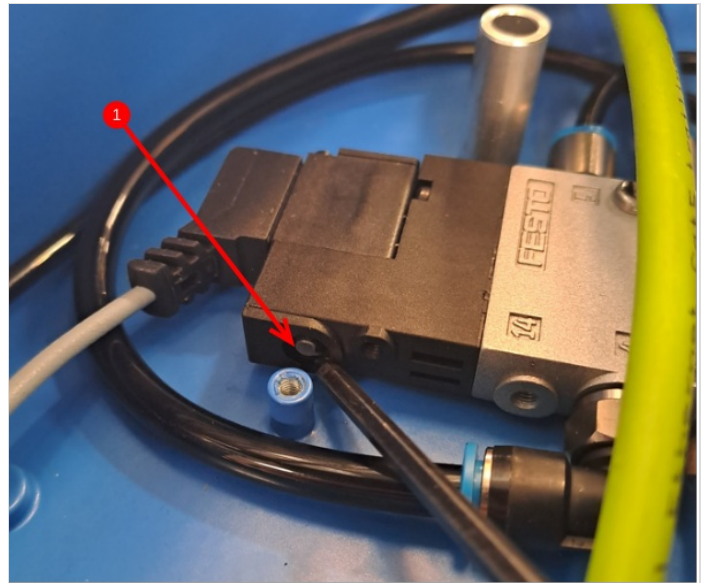
3 Reconnect air and confirm correct home position is now achieved



Step 5 - Manual valve activation

Valves can be activated manually by the control button. When pressed, the valve will fire the associated cylinder to its active position .

1 Manual valve activation button



Step 6 - Test single slide bases

4 off

Check that when valve is activated, spindle assembly goes to the position shown. Fire valve a few times to check movement is consistent. Cylinder speeds and cushioning will be set at a later point



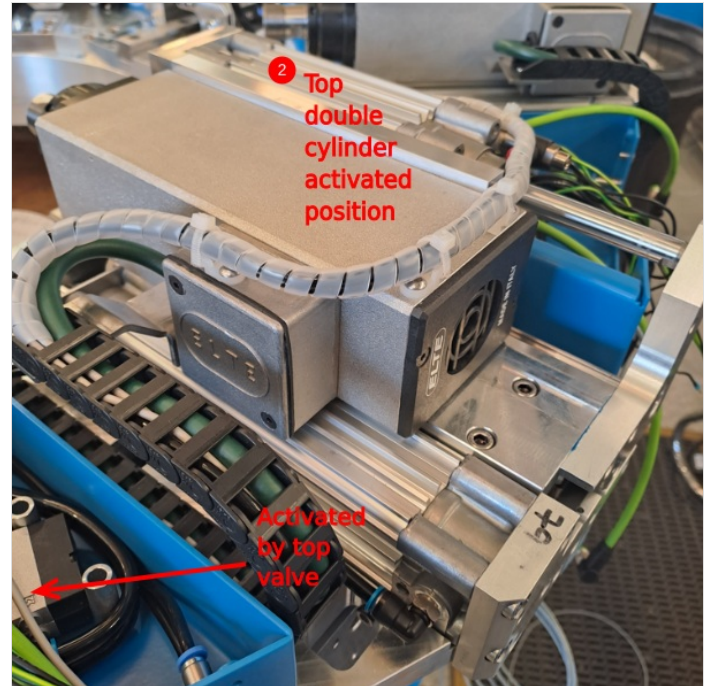
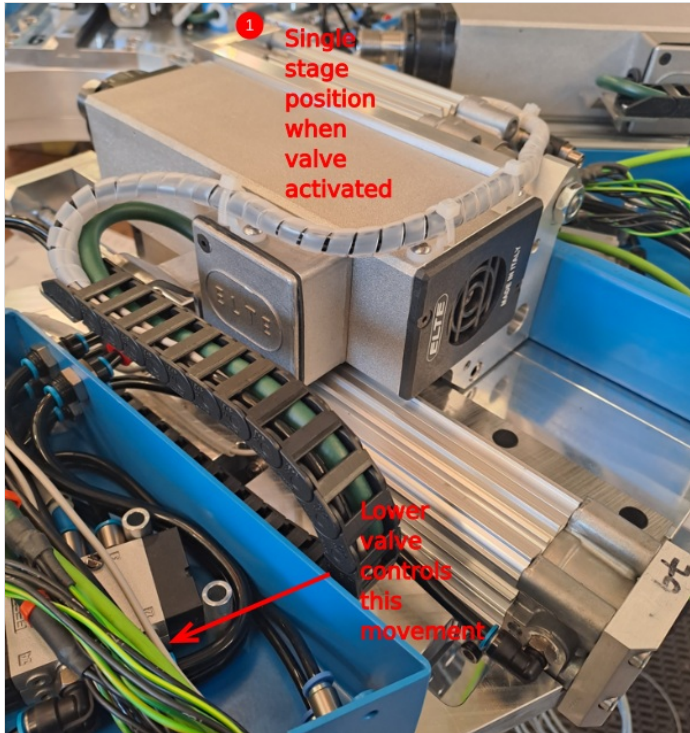
Step 7 - Test double slide bases

4 off

Check that when valve is activated, spindle assembly goes to the position shown. Fire valve a few times to check movement is consistent. Cylinder speeds and cushioning will be set at a later point

1 Single stage cylinder activated by lower valve , see image for details

2 Double stage cylinder activated by upper valve , see image for details



Step 8 - Disconnect air

Once pneumatic testing is complete disconnect the air supply
